

Ship Tues/Wed 22-23/03

Work Order ID 67401

Friday, March 18, 2011 10:48:13 AM



Page 1

Item ID: D3269-2

Accept



Setup

Start



Revision ID:

Item Name: Bubble Window, RH

Stop



Start Date: 3/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3269	Rev E

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up Clamping Frame and Load Program as per Folio FTA 014

x2

DL
11/03/21

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to 30" by 48"

x2

DL
11/03/21

120

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3269 and Folio FTA 014 || Dwg. Rev.

E || Folio Rev. C

x2

DL
11/03/21

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC2- Inspect parts off machine FAI/FAIB

0.00

x2

SL

QC

Quality Control

Memo

0.00

11/03/21

140



QC8- Inspect parts - second check

0.00

8 u03/21

(42)

QC

Quality Control

Memo

0.00

150



HAND FINISHING THERMOFORMING

0.00

(x2)

White
11/03/21

Thermoform

Thermoforming Machine

Memo

0.00

1) Trim off excess flange material! 2) Buff out any light scratches or blemishes! 3) Etch part number and batch number

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Accept



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Start Date: 3/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

3/18/21

(2)

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Packaging

PPPG7400

0.00

3/18/21 (2)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

3/18/21 (2)

3/18/21

Picklist Print

Friday, March 18, 2011 10:48:10 AM

Page 1

Work Order ID: 67401



Parent Item: D3269-2



Parent Item Name: Bubble Window, RH

Start Date: 3/17/2011

Required Date: 3/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 05.03.22 New issue KJ/JLM

IPP B 05.05.09 Added engraving EC

IPP Rev:06-07-03 As per Rev C JLM

IPP C 07.11.06 Thermoform in-house DL verified by:EC

IPP Rev: D 08.07.24 As per New Tool DL.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRYLICS.177		Purchased	No				sf	138.0009		22.916			

0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SHEET



Location	Loc Qty	Loc Code
therm	138.0009094	
116564	34.37	
116796	103.630909	

11/03/21

22.916 sq ft -

DART AEROSPACE LTD	Work Order:	67401
Description: Bubble Window, RH (R44)	Part Number:	D3269-2
Inspection Dwg: D3269 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Depth of bubble within tolerances	✓			
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: W.L. Date: 11/03/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	+/-0.25	9.75"	✓		TAPEOL-01	
6.2	0.036 Min	0.065"	✓		ULTRA	
3.8	0.057 Min	0.103"	✓		ULTRA	

Measured by: W.L. Date: 11/03/21

Audited by: S. Date: 11/03/21

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/DL	
B	09.10.16	Tolerances revised per Dwg Rev E	KJ	<u>W.L.</u> <u>W.L.</u>



